

Work Order ID 134232

Wednesday, July 08, 2015 10:43:06 AM

134232

Page 1

Item ID: D2565-401 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut 18.29"
 Start Date: 7/8/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/9/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference: ~~REWORK~~ RETURN

Approvals: Process Plan: ME Date: 15-7-8 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								

170

0.00

170

QC

Quality Control

Memo

0.00

STRUTS CAME IN ON RA111987 D2565-401 X 4:

1 X B126898 ✓

~~1 X B126896~~

1 X B118453 ✓

2 X B88300 ✓

(4) 15-07-08

DAS

9

9-89

SCUFF LIGHTLY AND REPOWDER COAT

180

180

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

Memo

0.00

SCUFF LIGHTLY AND REPOWDER COAT

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :						

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185 *185* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M131545. DAS 41 15-7-14 Memo 9-89 SCUFF LIGHTLY AND REPOWDER COAT	0.00 0.00	START: 1:10 CLEAN. Ti 400° FINISH 4:40.			N Ø 15-7-22			DAS 31 9-89
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(4)			DAS 38 9-89 JUL 23 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: ST358 Memo	0.00 0.00				(4) JA			DAS 27 9-89 JUL 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Work Order ID 134232***134232***

Page 3

Item ID: D2565-401

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut 18.29"

Stop ***NS2***

Start Date: 7/8/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/9/2015 Req'd Qty: 4.00

4

Customer:

Reference: REWORK

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

SH 20150727

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, July 08, 2015 10:43:06 AM

Page 1

Work Order ID: 134232

134232

Parent Item: D2565-401

D2565-401

Parent Item Name: Strut 18.29"

Start Date: 7/8/2015

Required Date: 7/9/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A04.05.10New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2565-401		Manufactured	No				Each	4.0000		4			

D2565-401

Strut 18.29"

Location

Loc Qty

Loc Code

ST358

4

126836

4

1 x 126898
~~1 x 126836~~
1 x 118453
2 x 88300

umf
15-7-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

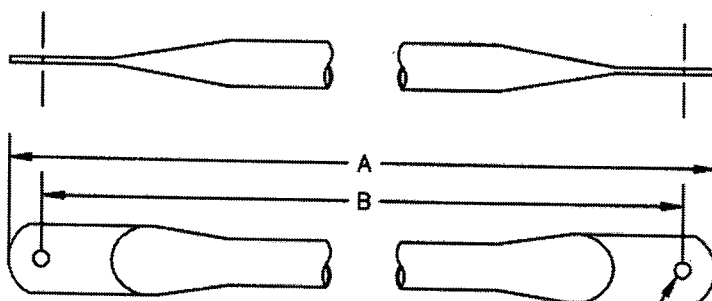
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05				TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE			
B	97.03.15	CORRECT D2565-111 DIM. A			
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)			
D	02.06.05	ADD -3XX PARTS; ADD FINISH			
E	04.05.05	ADD D2565-401-411; RMV ANGLE D			

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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RA111987

Received @ April 14, 2015
Inspected@ May 6, 2015

CUSTOMER: HAWKER PACIFIC-DUBAI
CUSTOMER CONTACT: MALCOLM COELHO
SHIPPED FROM: DUBAI

Instructions for RA111987 D205-633-017 B126835 CHG001

- Customer order wrong parts
- List of parts that was return with minor damage due to assembly by customer
 - D2563 B126064 4x
 - Create work order for touch up powder coat and wing walk on D2563 and return in stock new batch number - 134230
 - D2562-007 B126899 1x / B126839 2x / B90311 1x - 134231
 - D2565-401 B126898 1x / ~~B126836 1x~~ / B118453 1x / B88300 2x - 134232
 - D2565-403 B124437 2x / B126840 1x / B118454 1x - 134233
 - D2565-405 B126837 1x / B118455 1x / B88305 2x - 134234
 - D2565-407 B126895 1x / B110372 2x / B118456 1x - 134235
 - D2565-409 B47831 4x - 134236
 - D2565-411 B118458 1x / B123943 2x / B126838 1x - 134237
 - Create work order to strip and powder coat all D2565 and return in stock with new batch number
- List of parts that was not return
 - AN4-14A 1x
 - AN4-5A 2x
 - AN4-6A 2x
 - AN4-7A 2x
 - AN5-14 1x
 - AN5-6A 1x
 - D2021-101 1x
 - D2022-101 2x
 - D2022-103 2x
 - MS21042L4 8x
 - MS21042L5 2x
 - NAS1149D0463J 15x
 - NAS1149D0563J 4x

Time Estimate: 8 hours

Departments Required: quality, finishing, stores

Pictures Attached: N/A

QTY INSPECTED: 4x D205-633-017 B126835 CHG001

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : _____																									